

011727



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3-K

Job Sheet 199476



Part No: C3-K

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity - Keeperless



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/23/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 9/27/19

Type: Stock

Description: SIOP

Note: DWG C3-K Rev 3 IPP Rev A 18.03.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	External Load - 1	1 pcs	9/27/19		0.00	1.00	External Load - 1		
							External Load - 2		Michael
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	9/27/19		0.00	1.00	External Load - 1 - B4B		AP 2019/05/10
							External Load - 2 - B4B		Michael
							External Load - 3 - B4B		
110	QC 5	1 pcs	9/27/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		DAS
130	Packaging 3-2 - Stock - B4B	1 pcs	9/27/19		0.00	0.00	QC 5 - 30		30
							QC 5 - 40		9-89
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-2 - Stock - B4B	1 pcs	9/27/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



Container No: S211338



Part: C3 - K

Job No: 199476

Serial No/Batch: S211338

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartero.com
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Date: 08/04/19

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				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B	DAS	
				Packaging 3 - 8 - B4B	30 SEP 10 2019	
				Packaging 3 - 9 - B4B	9-89	
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
135	DC - 1 - B4B	1 pcs	9/27/19	0.00 0.00	DC - 1 - B4B	DAS
					DC - 2 - B4B	21 SEP 11 2019
140	QC 21 - SA	1 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	9-89
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21 SEP 11 2019

Part Op 95 - Issue S/N

Descriptions: 100 - (Small Fab)1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 2. 2-

ASSEMBLE AS PER DWG

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)Identify and Stock

135 - (Document Control)Photocopy blue file OM & OOPM-C3 Rev 4

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	5110 495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	5126 989
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	5073 047
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	5074 909
8183K6	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	5118 667
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	5180 311

AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5157429-3
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5183433
C2-1-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B	5190045
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5068051
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B	5061528
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B	5177832
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B	5180410
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B	5174393
C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5173563
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B	5168898
FO C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5125627
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B	5182513
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B	5111642
2 C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B	5148221
C2-3-8	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5178019
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B	5072964
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5197483
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5182333
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5193685
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5080193
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5190711
C3-12-4 PO	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5125633
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5100174
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B	5206297
C3-13-1	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5206235
C3-13-4-2	Keeperless Adapter	1 pcs (1 ea)	100-External Load - 2 - B4B	5129082
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5175253
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B	5118503
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-External Load - 2 - B4B	5137712
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B	5048390
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5128685
C3-4-1	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5192917
1 C3-4-4KA	Keeperless Load Beam Assembly - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5059062
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	5186739
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B	5189979
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B	5156744
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B	5180680
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B	5153419
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5116296
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B	5089524
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B	5192574
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B	5075144
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B	5203176
MS21083-N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B	5142051
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	5180294
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	5183289
NAS1149F0332P	Washer (AN960-10L)	2 Ea (2 ea)	100-External Load - 2 - B4B	5103666-1
NAS1149F0363P	Washer (AN960-10)	1 Ea (1 ea)	100-External Load - 2 - B4B	5027738
NAS1149F0463P	Washer (AN960-416)	8 Ea (8 ea)	100-External Load - 2 - B4B	5201001
NAS1149F0632P	Washer (AN960-616L)	2 Ea (2 ea)	100-External Load - 2 - B4B	5137711

GREASE AEROSHELL 20.7 : (S138964)
 LOCTITE 242 : (S186572)
 LOCTITE 620 : (S194792)
 ANTI-SEIZE : (M128063)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	111	0
	188-FSCS-832-5/8	4	205	0
100-External Load - 2 - B4B	2595K22	1	28	0
	32446	2	630	0
	8183K6	1	24	0
	AN4-16A	3	506	0
	AN4-17A	1	283	0
	AN6-15A	1	24	0
	C2-1-1	1	11	0
	C2-10-1	1	67	0
	C2-11-2	2	42	0
	C2-3-1	2	68	0
	C2-3-10	1	13	0
	C2-3-11	1	21	0
	C2-3-2	1	24	0
	C2-3-2-1	2	32	0
	C2-3-3	1	44	0
	C2-3-3-1	1	28	0
	C2-3-5	2	105	0
	C2-3-6	1	5	0
	C2-3-8	2	50	0
	C2-5-1	1	5	0
	C3-10-2	1	28	0
	C3-11-1	1	14	0
	C3-12-1	2	44	0
	C3-12-2	1	19	0
	C3-12-3	1	23	0
	C3-12-4	1	28	0
	C3-12-5	1	32	0
	C3-12-6	2	106	0
	C3-13-1	2	70	0
	C3-13-4-2	1	12	0
	C3-2-1	1	15	0
	C3-3-4	2	6	0
	C3-3-4-1	4	122	0
	C3-3-7	1	14	0
	C3-3-9	1	33	0
	C3-4-1	2	43	0
	C3-4-4KA	1	8	0
	C3-7-1	1	17	0
	C3-7-2	2	28	0
	C3-8-2	1	4	0
	C3-8-4	1	21	0
	C3-8-5	1	23	0
	C3-9-1	1	14	0
	C3-9-2	1	32	0
	EL-PLUG-M	1	28	0
	M27500-16TG2T14	1	42	0
	MS21044N4	4	77	0
	MS21083-N3	2	41	0
	MS21083N6	1	50	0
	MS35266-63	1	22	0
	NAS1149F0332P	2	2,894	0
	NAS1149F0363P	1	360	0
	NAS1149F0463P	8	518	0
	NAS1149F0632P	2	316	0

Part Specifications

Specifications could not be found.

Plex 8/23/19 1:08 PM Dart.Renwick.Jennifer

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 199476

Customer _____

Serial Number 5211338

Date 2019-9-6

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	<u>Pass</u>
10	1,500	Electrical, 25 volts	No "hang ups" permitted	N/A	<u>Pass</u>
2	3,000	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>8.9</u> A	<u>Pass</u>
2	2,500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>8.8</u> A	<u>Pass</u>
2	2,000	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>8.7</u> A	<u>Pass</u>
2	1,500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>8.7</u> A	<u>Pass</u>
2	500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>8.8</u> A	<u>Pass</u>
1	3,000	Electrical, 20 volts	Current shall not exceed 11.6 A	<u>8.0</u> A	<u>Pass</u>
1	3,000	Electrical, 28 volts	Current shall not exceed 16.2 A	<u>11.5</u> A	<u>Pass</u>
1	3,000	Manual		N/A	<u>Pass</u>
1	3,000	Impact Test	Impact shackle 10x, shall not release	N/A	<u>Pass</u>
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω	<u>1.7</u> Ω	<u>Pass</u>
1	N/A	Electrical Continuity	Across both wires	N/A	<u>Pass</u>

Test Conducted By: Mechel Leland
Technician

Signature: Sylvia Boncher
QC 5 Small FAB / QA

Submit